

# Work Order ID 83531

**\*83531\***

Page 1

April-19-12 11:21:44 AM

Item ID: D350-567-141

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Floor Window Closeout Installation

Stop **\*NS2\***

Start Date: 19/04/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/12 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
DSI 9590	C								
100	DOCUMENT CONTROL	0.00							
<b>*100*</b>									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D350-567-141 CHG002								
110	Pick Kit	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 12/06/12

8/12/12

12/14/12

8/12/12

(HS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83531****\*83531\***

Page 2

April-19-12 11:21:44 AM

Item ID: D350-567-141

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Floor Window Closeout Installation

Start Date: 19/04/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-567-141

Location: \_\_\_\_\_

**86 590**

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

**MLJ 12/07/12****ME  
12-07-12**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 83531

\*83531\*

Parent Item: D350-567-141

\*D350-567-141\*

Parent Item Name: Floor Window Closeout Installation

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 5.00

Required Qty: 5.00

## Comments:

IPP REV:A 11.11.09 new issue DD verf:JLM  
12.01.23 AS PER ECN12-511 DD VERF:EC  
AS PER ECN12-537 DD VERF:EC

IPP REV:B  
IPP REV:C 12.03.05

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3802-1		Manufactured	No			110	f	517.7500	2	10			
---------	--	--------------	----	--	--	-----	---	----------	---	----	--	--	--

\*D3802-1\*

Window Seal

\*\*

sf

### Location

### Loc Qty

### Loc Code

ST412

517.75

56881

0.75

81021

17

81868

500

70 feet

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

D4434-041

Manufactured No

110

Each

4.0000

\*\*

5

\*D4434-041\*

Fwd Bracket Assembly

3x82292

### Location

### Loc Qty

### Loc Code

ST

-4

80662

4

ST441

8

2

D4434-047

Manufactured No

110

Each

11.0000

\*\*

5

\*D4434-047\*

Cover Assembly

sf

### Location

### Loc Qty

### Loc Code

ST441

11

82291

11

5

D4435-045

Manufactured No

110

Each

0.0000

\*\*

5

\*D4435-045\*

T/R Bellcrank Cover Assembly

382290

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*83531\*

Parent Item: D350-567-141

\*D350-567-141\*

Parent Item Name: Floor Window Closeout Installation

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 5.00

Required Qty: 5.00

D4435-9 Manufactured No

110 Each 11.0000

2 10

\*\*

3y  
B83474 sf

\*D4435-9\*  
Bracket

## Location

## Loc Qty

## Loc Code

ST441

11

82294

11

D4436-041 Manufactured No

110 Each 0.0000

0 5

\*\*

7  
83532

\*D4436-041\*  
Aft Bracket Assembly

## Location

## Loc Qty

## Loc Code

ST

-9

ST441

9

D4441-1 Manufactured No

110 f 63.7986

2 10

\*\*

sf

\*D4441-1\*  
Rubber Seal

## Location

## Loc Qty

## Loc Code

prelim

6.739

74760

6.739

ST413

57.0596

79385

49.8636

80763

7.196

(D4441-1-240) CUT (1) AT 24.00" PER KIT

AN3-3A Purchased No

110 Each 369.0000

7 35

\*\*

10 feet

\*AN3-3A\*  
Bolt

## Location

## Loc Qty

## Loc Code

ST350

369

120423

369

35

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 83531

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

\*83531\*

\*D350-567-141\*

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 5.00

Required Qty: 5.00

AN525-832R7

Purchased

No

110

Each

528.0000

2 1

10

\*\*

sl

\*AN525-832R7\*

Screw

Location

Loc Qty

Loc Code

ST345

528

120519

68

120560

460

Purchased

No

110

Each

156.0000

10

35

\*\*

M121444

sl

MS21042L06

\*MS21042L06\*

Nut

Location

Loc Qty

Loc Code

ST300

156

118354

2

119109

1

119758

1

120360

152

Purchased

No

110

Each

162.0000

2

10

\*\*

M121524

12/6/28 sl

MS21042L08

\*MS21042L08\*

Nut

Location

Loc Qty

Loc Code

ST300

162

120833

158

121185

4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 83531

\*83531\*

Parent Item: D350-567-141

\*D350-567-141\*

Parent Item Name: Floor Window Closeout Installation

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

110

Each

2,849.000



25

\*\*

sf

\*MS21042L3\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

2849

117441

16

117885

32

118451

5

118927

3

119017

1635

119075

158

121349

1000

25

MS21059L3

Purchased

No

110

Each

207.0000



10

\*\*

sf

\*MS21059L3\*

Nut Plate

M106042 sf

## Location

## Loc Qty

## Loc Code

302

100

121185

100

ST301

28

118614

8

119546

20

ST302

79

120308

13

120833

1

121011

65

8

MS35206-229

Purchased

No

110

Each

170.0000



35

\*\*

12/4/28 sf

\*MS35206-229\*

Screw

## Location

## Loc Qty

## Loc Code

ST293

170

121039

170

35

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Work Order ID: 83531

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

\*83531\*

\*D350-567-141\*

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 5.00

Required Qty: 5.00

NAS1149F0332P

Purchased

No

110

Each

588.0000



60

\*\*

M/12/8250

\*~~NAS1149F0332P~~\*

WASHER

## Location

## Loc Qty

## Loc Code

ST275

588

117735

25

119225

10

120910

150

120986

200

121259

200

17317

3

NAS1149FN616P

Purchased

No

110

Each

851.0000



70

\*\*

sf

\*~~NAS1149FN616P~~\*

WASHER

## Location

## Loc Qty

## Loc Code

ST275

851

117317

15

120560

836

Each

755.0000



10

\*\*

12/6/2850

NAS1149FN816P

Purchased

No

\*~~NAS1149FN816P~~\*

WASHER

## Location

## Loc Qty

## Loc Code

ST275

755

117316

215

121039

540

10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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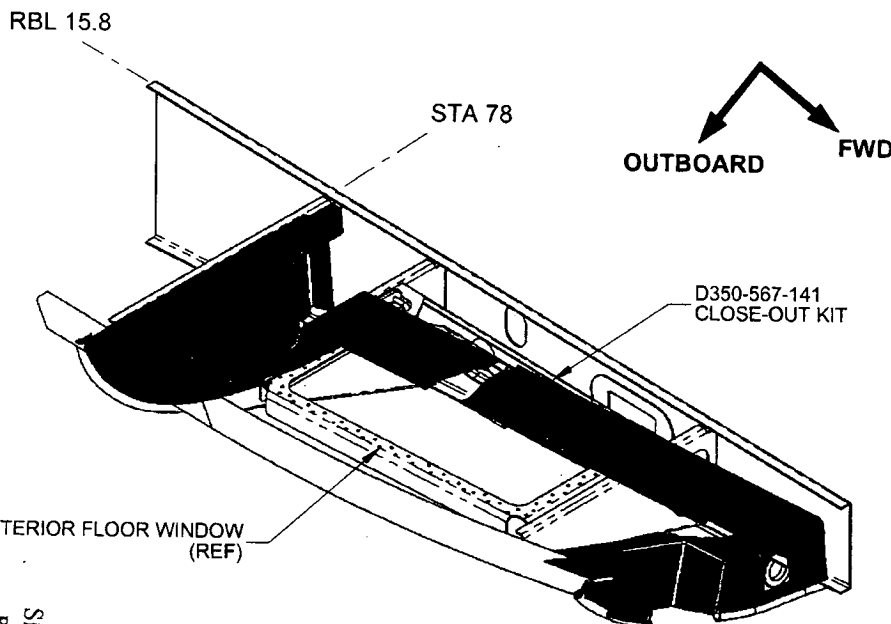
**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D OR EARLIER  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1 OR EARLIER  
REF CANADIAN STC: SH92-18  
FAA STC: SH989NE  
FAA STC: SH990NE

## 1.0 Purpose

The purpose of this service instruction is to add the D350-567-141 Close-out Kit, which is intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141 Floor Window Close-out Kit provides a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1.



**Figure 1. Floor Window Close-out Kit Installation**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 12.03.13  
CERT. NO.: SH92-18  
ISSUE NO.: 6

C	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P	RF	12.03.13
B	MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	12.03.13	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

## 2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)

## 3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

## 4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
  - D350-567-115 — OK to remove D3295-041
  - D350-567-031 — OK to remove D3212-1
  - D350-567-011 — OK to remove D2214
  - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

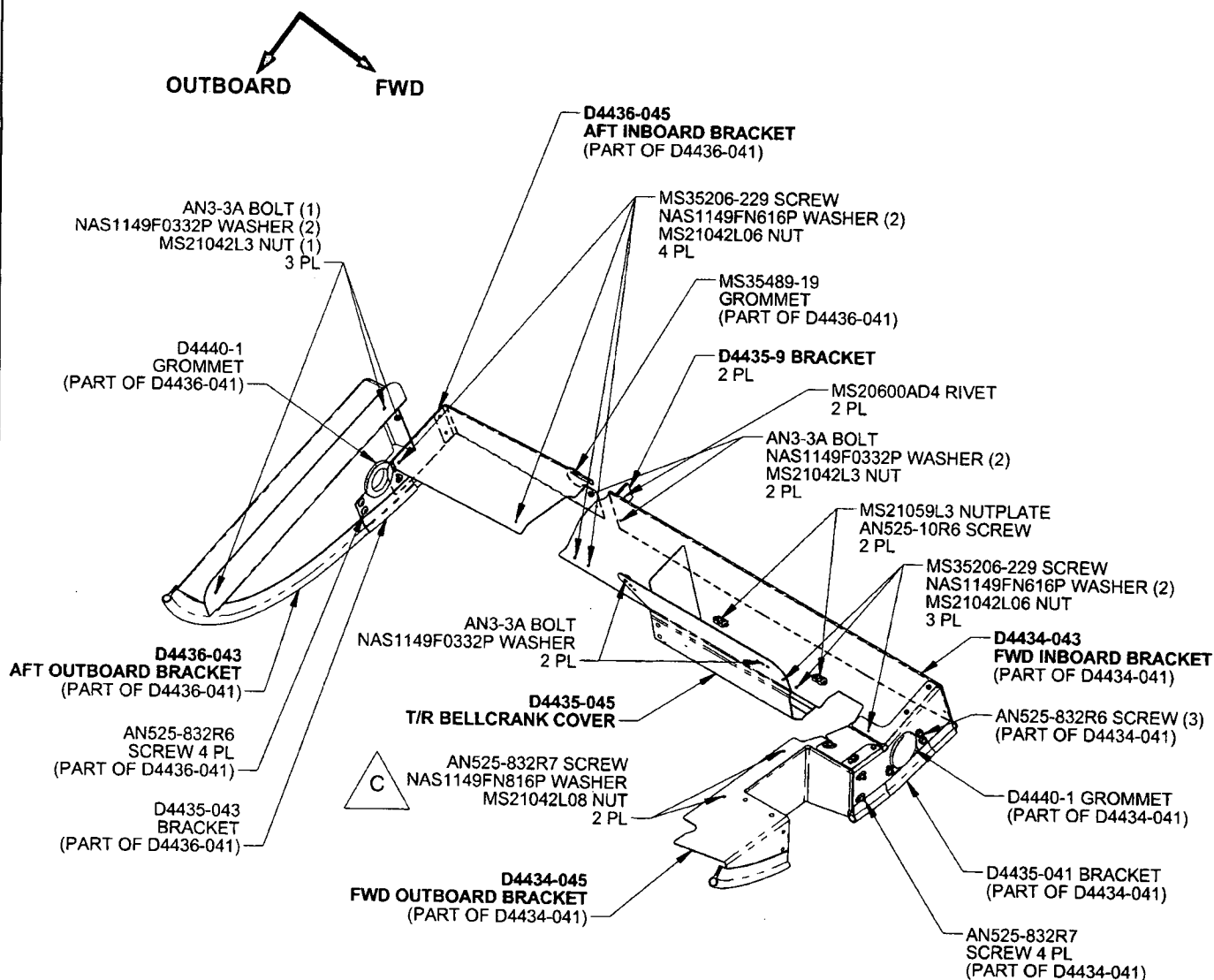
BY: M. Shepherd  
D. SHEPHERD (DE # 02)

DATE: 12.03.13  
CERT. NO.: SH92-18  
ISSUE NO.: 6

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MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 12
APPROVED	<u>JS</u>	TITLE	SCALE
DE APPR.	<u>JS</u>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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**Figure 2. Floor Window Close-out Kit Installation**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-Q-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 12.03.13  
CERT. NO.: SH92-18  
ISSUE NO.: 6

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CHECKED	<i>[Signature]</i>	DRAWING NO. <b>DSI 9590</b>	REV. C
MFG. APPR.	N/A	SHEET 3 OF 12	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>FLOOR WINDOW CLOSE-OUT KIT</b>	NTS
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- 4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or clecos clamps. Before drilling holes:
- Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
  - Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.
- 4.2 Temporarily install D4434-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.
- 4.3 If aircraft is equipped with Collective Circuit Breaker Board box trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4434-047 Cover as shown in Figure 13. Note: Confirm the D4434-047 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.4 Drill off rivets holding plastic wire bundle stand offs. Transfer drill  $\varnothing 0.144$  holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x  $\varnothing 0.144$  holes to D4434-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x  $\varnothing 0.144$  holes for D4434-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.
- 4.5 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.
- 4.6 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x  $\varnothing 0.129$  holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.
- 4.7 Drill a pilot hole from D4435-9 Bracket to the D4434-045 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to  $\varnothing 0.191$ . Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.
- 4.8 Transfer drill 2 x  $\varnothing 0.144$  holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x  $\varnothing 0.144$  holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 Screws, NAS1149FN816P washer and MS21042L08 nuts.
- 4.9 Align D4435-045 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12.
- 4.10 Transfer drill 2 x  $\varnothing 0.098$  holes from D4435-045 T/R Bellcrank Cover to D4434-043 Fwd Inboard Bracket. Open holes to  $\varnothing 0.191$  and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12 and Figure 13. Install D4435-045 T/R Bellcrank Cover using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12 and Figure 13.
- 4.11 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.12 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.13 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.14 Ensure there is a gap between the components of the D350-567-141 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-041 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.



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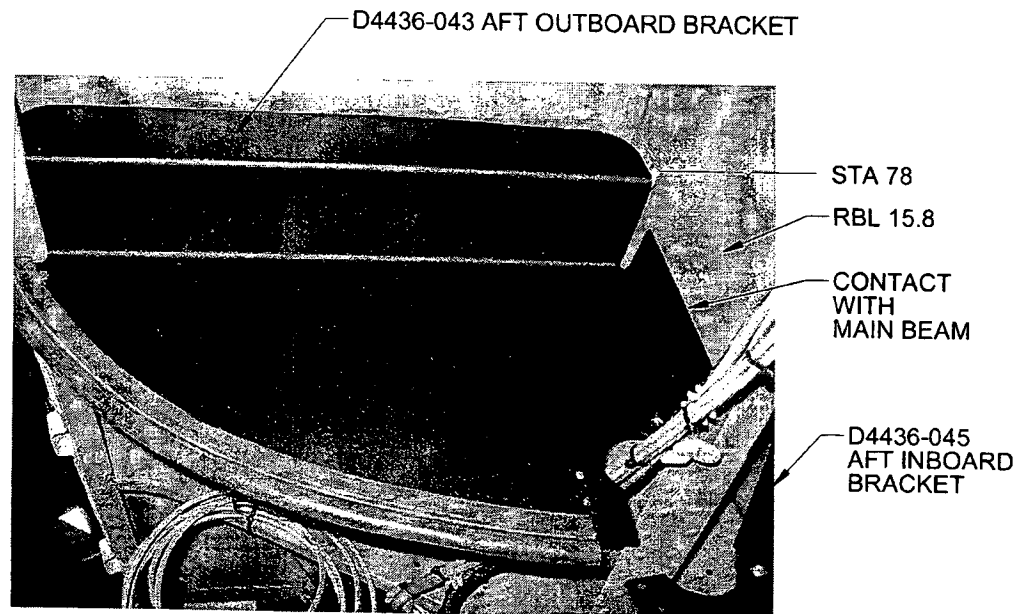
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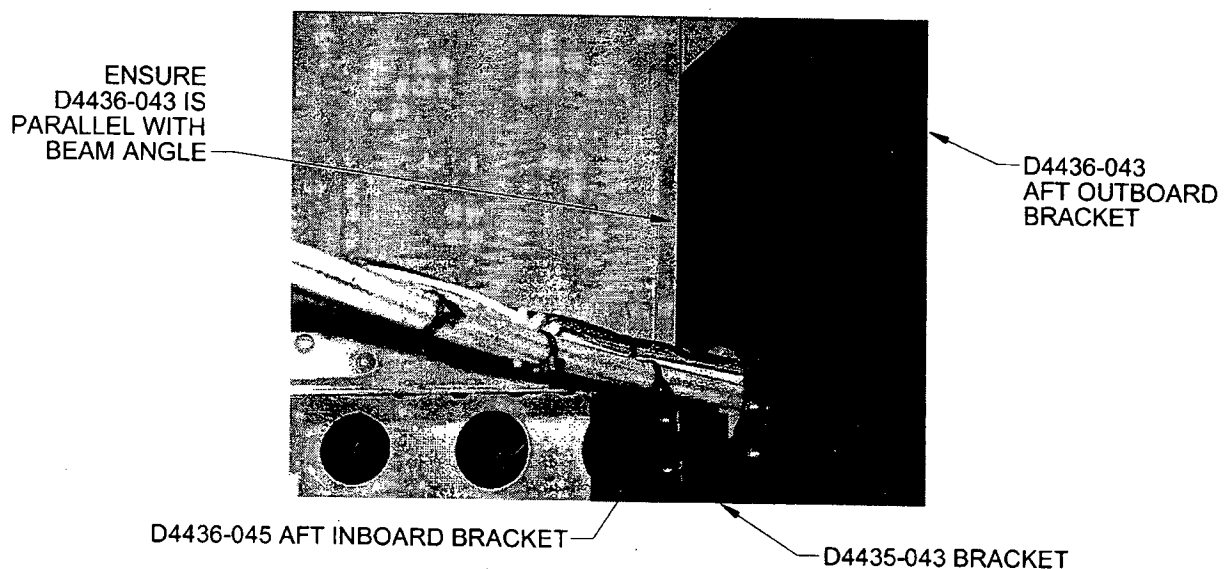
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**Figure 3. D4436-043 Aft Outboard Bracket Installation**



**Figure 4. D4436-043 & D4435-043 Brackets Installation**

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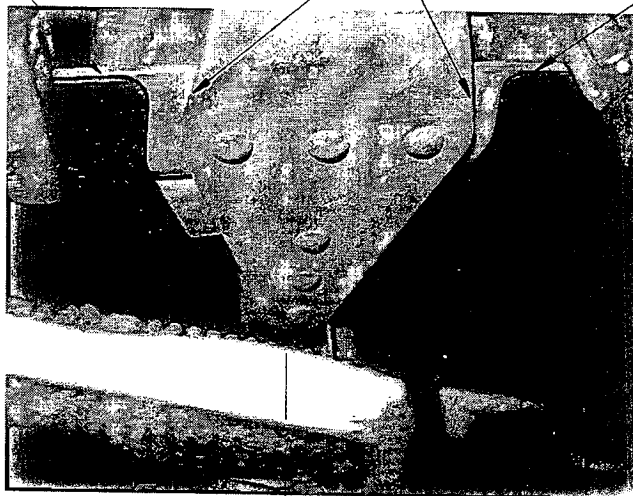
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D4436-045 AFT INBOARD  
BRACKET

NO CONTACT  
WITH GUSSET

D4434-043 FWD INBOARD  
BRACKET

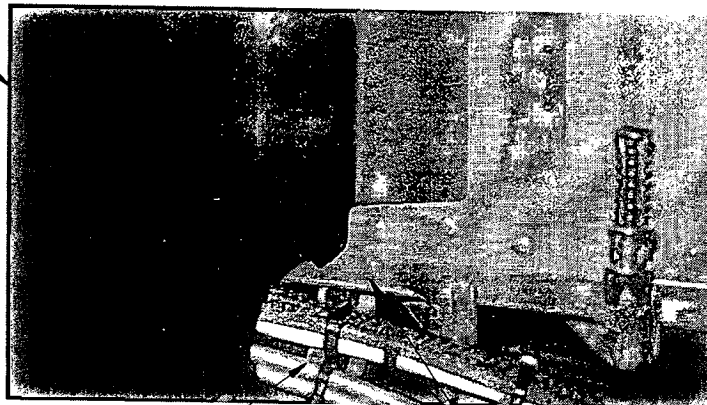
RBL 15.8 - - -



STA 70.5

**Figure 5. D4436-045 & D4434-043 Brackets Installation**

D4436-043  
AFT OUTBOARD  
BRACKET



CONFIRM  
FLUSH WITH  
OUTBOARD  
EDGE OF MAIN  
BEAM FLANGE

PLASTIC STAND OFF  
REF

RIVET HOLE  
FOR PLASTIC  
STAND OFF

D4436-045  
AFT INBOARD  
BRACKET

**Figure 6. D4436-043 & D4436-045 Brackets Installation**

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CONFIRM  
FLUSH WITH  
OUTBOARD  
EDGE OF MAIN  
BEAM FLANGE

D4436-045  
AFT INBOARD  
BRACKET

PLASTIC STAND OFF  
REF

RIVET HOLES  
FOR PLASTIC  
STAND OFF

--- RBL 15.8

D4434-043 FWD INBOARD  
BRACKET

**Figure 7. D4434-043 & D4436-045 Brackets Installation**

CONFIRM  
FLUSH WITH  
OUTBOARD  
EDGE OF MAIN  
BEAM FLANGE

RIVET HOLES  
FOR PLASTIC  
STAND OFF

--- RBL 15.8

D4434-043 FWD INBOARD  
BRACKET

**Figure 8. D4434-043 Fwd Inboard Bracket Installation**

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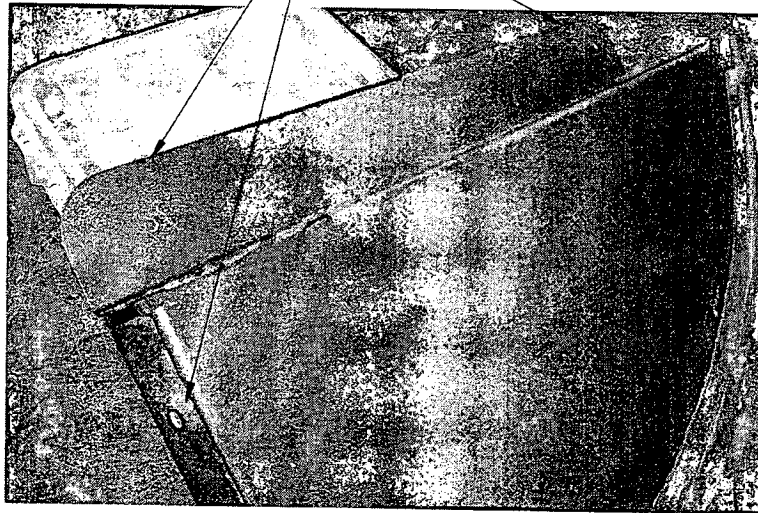
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INSTALL  
D4436-043  
AFT OUTBOARD BRACKET  
USING  
AN3-3A BOLT (1)  
NAS1149F0332P WASHER (2)  
MS21042L3 NUT (1)  
3 PL



**Figure 9. D4436-043 Aft Outboard Bracket Installation**

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DAO # 01-O-01

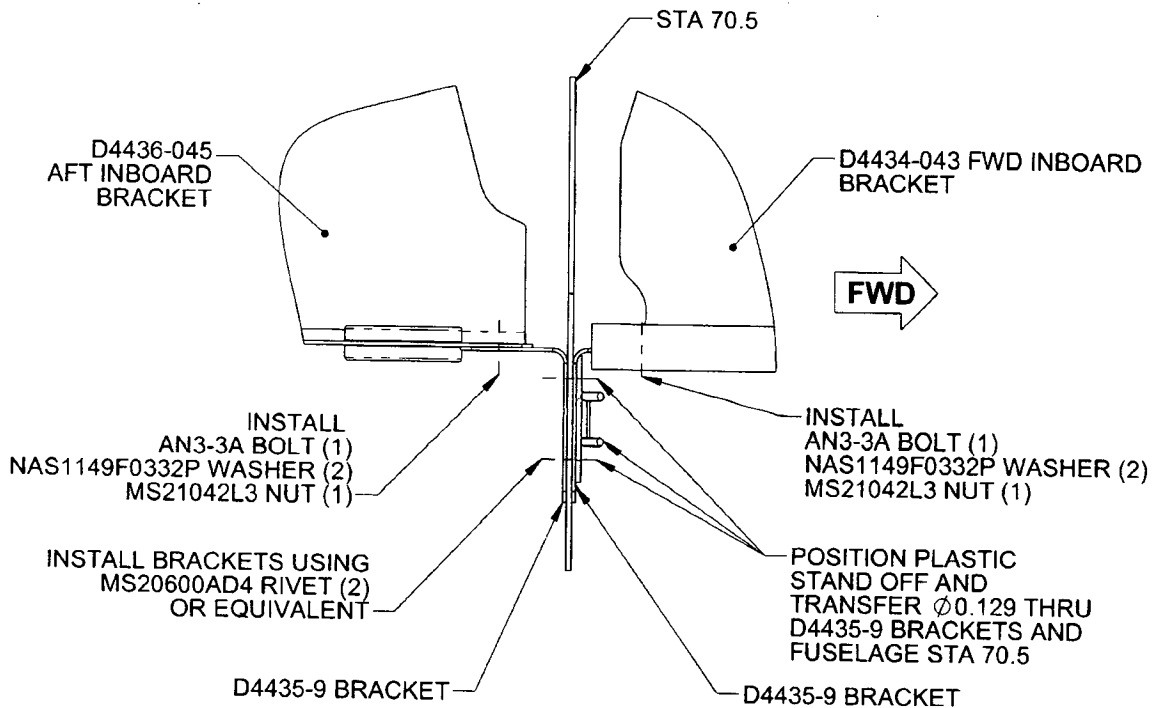
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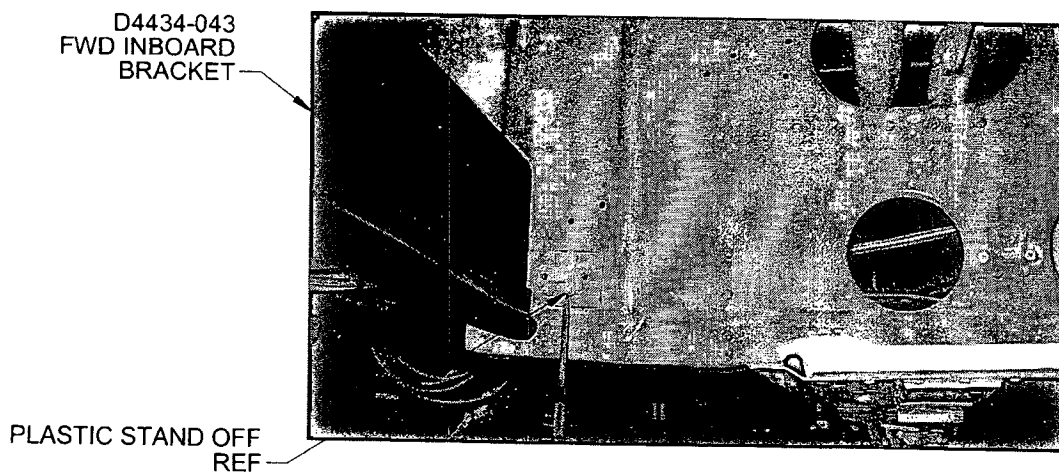
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**LOOKING UP AT STA 70.5**



**Figure 10. D4434-043 and D4435-9 Brackets Installation**

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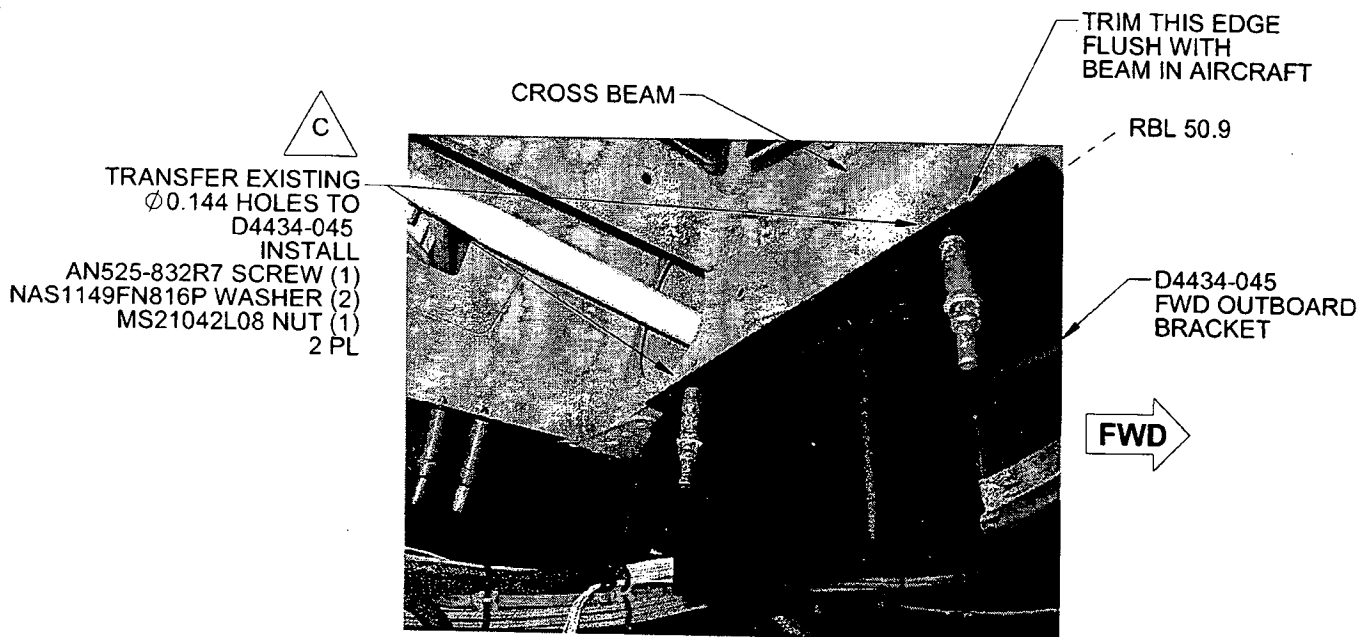
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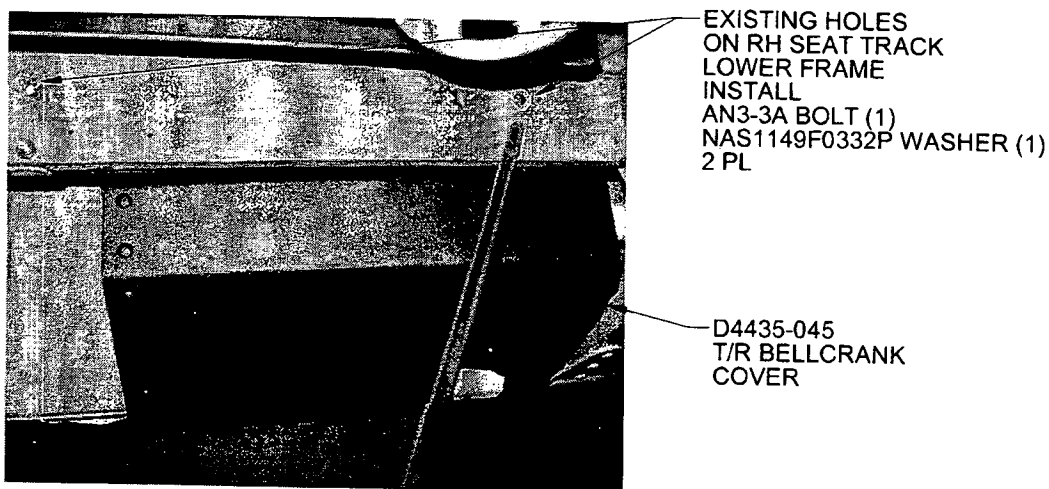
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**Figure 11. D4434-045 Bracket Installation**



**Figure 12. D4435-045 T/R Bellcrank Cover Installation**

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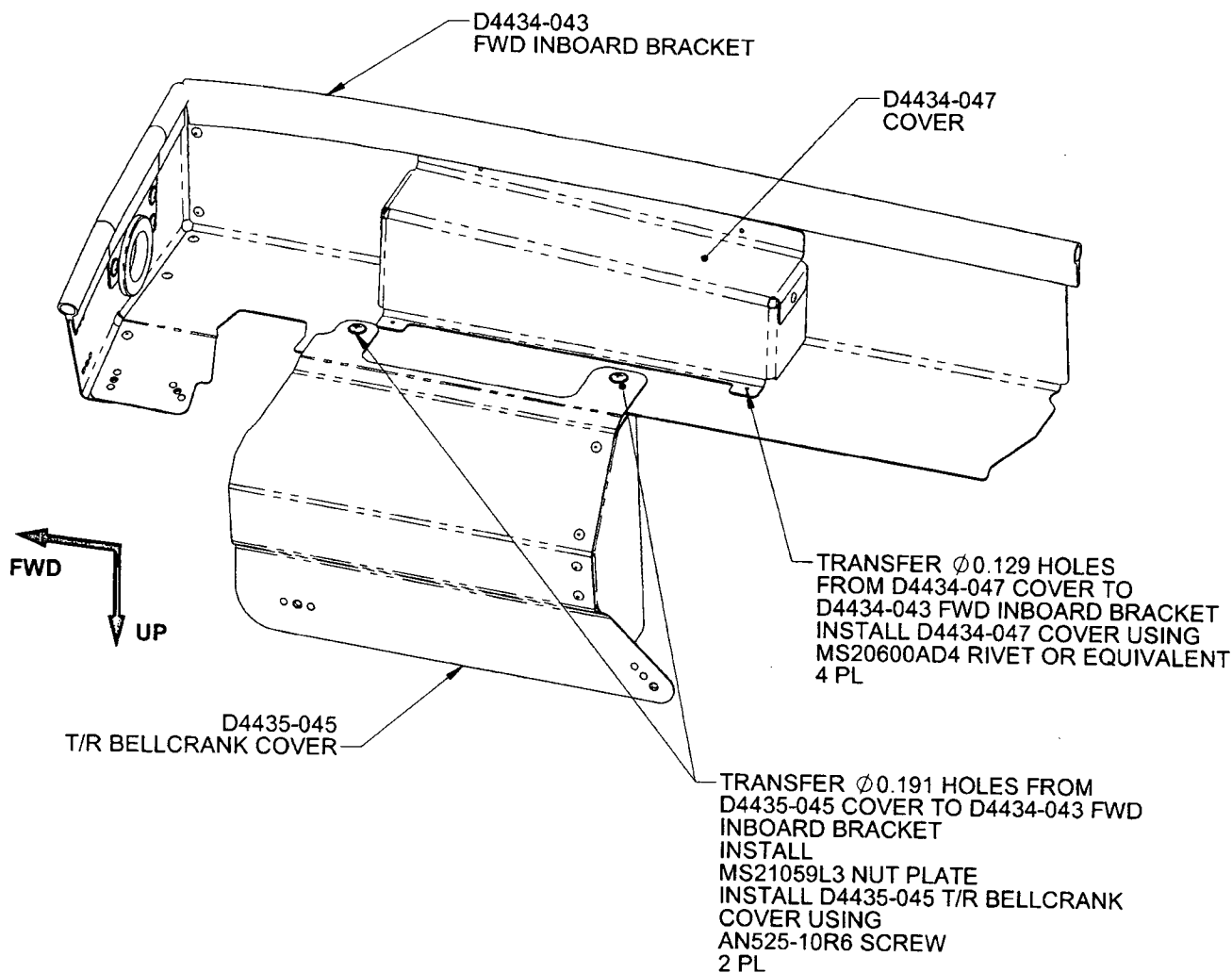
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**Figure 13. D4435-045 & D4434-047 Cover Installation**

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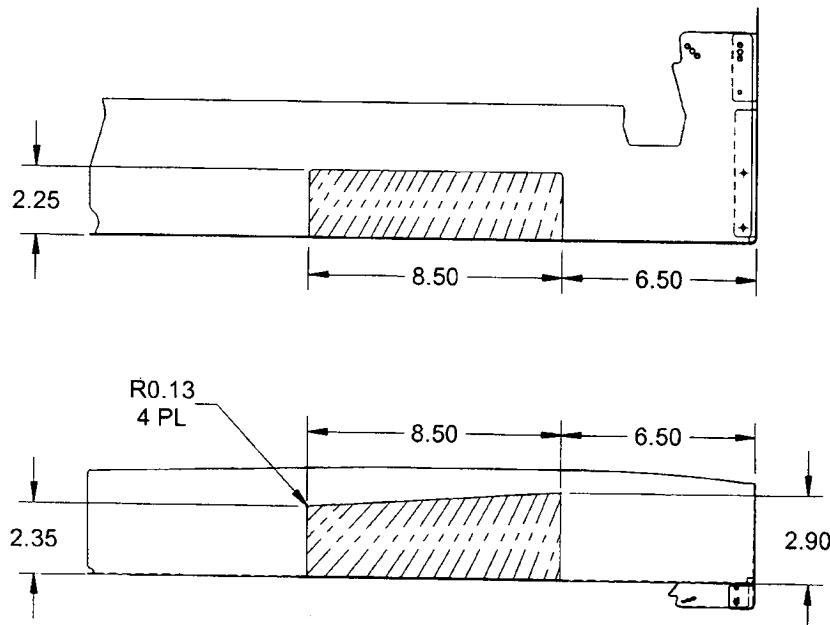
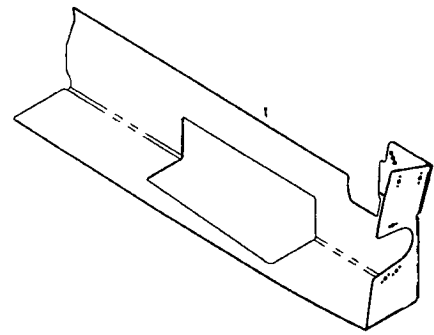
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**Figure 14. D4434-043 Fwd Inboard Bracket Cutout**

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## 2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)

## 3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

## 4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
  - D350-567-115 — OK to remove D3295-041
  - D350-567-031 — OK to remove D3212-1
  - D350-567-011 — OK to remove D2214
  - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

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